Work Order ID 50294

July 14, 2009 11:41:04 AM

Item ID: D3151-041 **Accept**

Revision ID: C

Item Name: Doubler Assembly

Setup **Start** **Stop**

Start Date: 7/15/09 **Start Qty:** 4.00

Required Date: 7/15/09 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3151	Rev C

100 Small Fab Small Fab	Small Fab **Memo** Assemble as per Dwg D3065 and Identify as D3065-041	0.00 0.00				EJS 09/08/18			(8)
110 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	=> S 09/08/18			(x8)	0		
120 Packaging Packaging	Identify as per dwg & Stock Location: 67 **Memo**	0.00 0.00				PC 9/8/15			(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 50294

July 14, 2009 11:41:04 AM

Item ID: D3151-041
Revision ID: C
Item Name: Doubler Assembly

Start Date: 7/15/09 **Start Qty:** 4.00
Required Date: 7/15/09 **Req'd Qty:** 4.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00	09/08/254			XS	BS	09-8-25	
QC	**Memo**	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:41:04 AM

Work Order ID: 50294

Parent Item: D3151-041RevC

Parent Item Name: Doubler Assembly

Comments:

Start Date: 7/15/09 **Required Date:** 7/15/09

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-1RevB		Manufactured	No			100	Each	90.0000	4.0000			
Step Spacer												

N/A

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	90	
46333	39	
48113	51	

PTO

D3065-3RevB		Manufactured	No			100	Each	30.0000	4.0000			
Step Spacer												

N/A

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	30	
48113	30	850387

8

D3151-1RevC		Manufactured	No			100	Each	0.0000	4.0000			
Bracket Flat Pattern												
D3151-3RevC		Manufactured	No			100	Each	0.0000	4.0000			
BRACKET												

B 50319

8

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W/O: 50294		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
09.08.14		Remove parts N/A to this P/N !	CE	09.08.26			

Part No: D3151-041 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:41:04 AM

Work Order ID: 50294

Parent Item: D3151-041RevC

Parent Item Name: Doubler Assembly

Comments:

Start Date: 7/15/09 **Required Date:** 7/15/09

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased	No			100	Each	8,232.000	24.0000			
Rivet												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	8232		
1563	0		
19099	4776		
7681	3456		48

MS20426AD3-4		Purchased	No			100	Each	8,385.000	16.0000			
RIVET												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	8385		
104374	4385		32
110398	4000		

MS21059L08		Purchased	No			100	Each	55.0000	8.0000			
Nut												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	55		
12706	55		16

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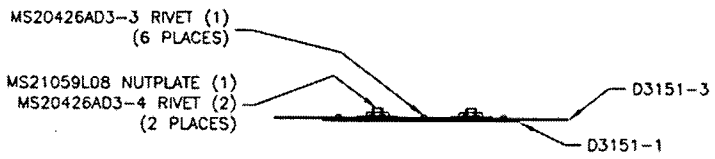
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

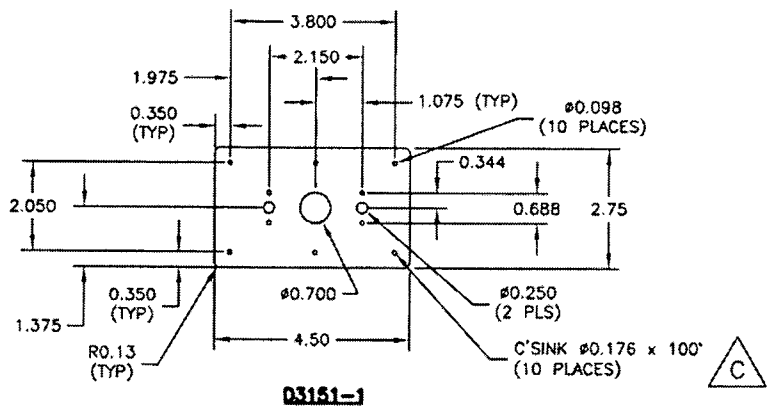
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
RF	RF	
CHECKED	APPROVED	DRAWING NO. REV. C
		D3151 SHEET 1 OF 1
DATE		TITLE SCALE
05.12.07		DOUBLER ASSEMBLY 1:4

A	02.04.23	NEW ISSUE
B	04.09.08	RE-DESIGN
C	05.12.07	REVISE NOTES

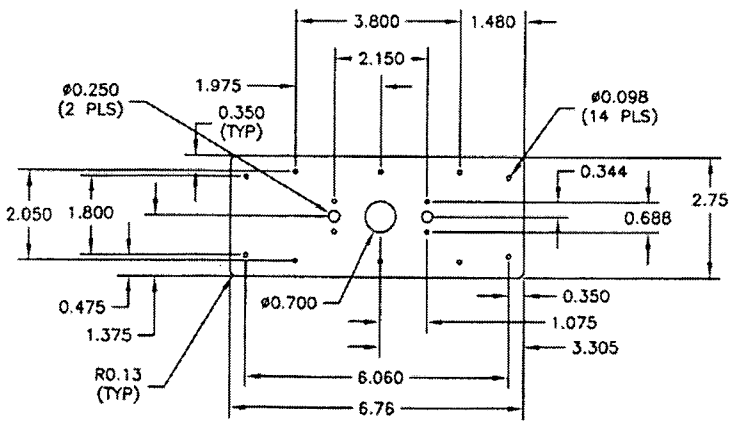


RELEASED
05.12.07

D3151-041 DOUBLER ASSEMBLY
REPLACES PREMIER P/N B30-23000-173/-174



D3151-1



D3151-3

NOTES
1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
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